

Date: Tuesday, 4/17/2007 11:08:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD TUBE ASSEMBLY
 Job Number : 31849
 Estimate Number : 10467
 P.O. Number : *N/A*
 This Issue : 4/17/2007 S.O. No. *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 31810
 Written By :
 Checked & Approved By : *APR 17 2007*
 Comment : Est. A 05.00.13 New issue KJJ/JLM
 Est. B 06.02.10 Dwg rev.D ech 773 EC
 Est. C 06.05.02 Added inspections EC
 est D 07.03.13 rev F dwg EC

Part Number : D3391021
 Drawing Number : D3391 REV.F
 Project Number : N/A
 Drawing Revision : F
 Material : *N/A*
 Due Date : 5/10/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6013047 SKIDTUBE MAT'L



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SKIDTUBE MAT'L

Pick:

Qty Part Number Description
 1 D6013-047 Extrusion

Batch

B 26547 BE 07-04-19

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 Cut extrusion to 46.52 +0.010 -0.020

BE 07-04-19

3.0 BENDING BENDING MACHINE



Comment: No bender
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-5-7

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-8

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *F*
 Identify as D3391-1

2-Deburr

J.F. 07/05/16

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/16

①

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Drill X1 Aft cap as per Dwg D3391

BG 07-05-22

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07-05-22

①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/05/22

①

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

DD
7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.A. 05-25-22

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Up 7-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/07/19 ①

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/m-l 07-07-19 ②

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/07/23 ①

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

20 *14*

NAS1330C3KB166

Insert

M102849

m-l

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

m-l 07/07/23 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/23 ②

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

B31346 m-l

07/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



m.d

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE

B 31347

21.0

D356613

GASKET



m.d

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET

B 31399

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
4 AN3C4A Bolt

M104955

m.d

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Pick:
Qty Part Number Description Batch
4 NAS1515H3L Washer

M104603

m.d

24.0

AN960C10L

washer



m.d

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
washer

M103057

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

M.A

07/07/24

26.0

QC5

INSPECT WORK TO CURRENT STEP



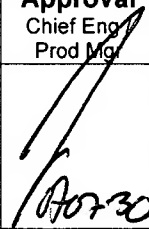

① →

Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

Inspect to current step

for 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mg	Approval QC Inspector	
07/07/24	26.0	Change step 26.0 to inspect to current step	En	07/07/24				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: R2 Date: 07/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:08:51 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31849

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP

33526

6/7/30

28.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

DATA/31

Job Completion



u 07-07-30

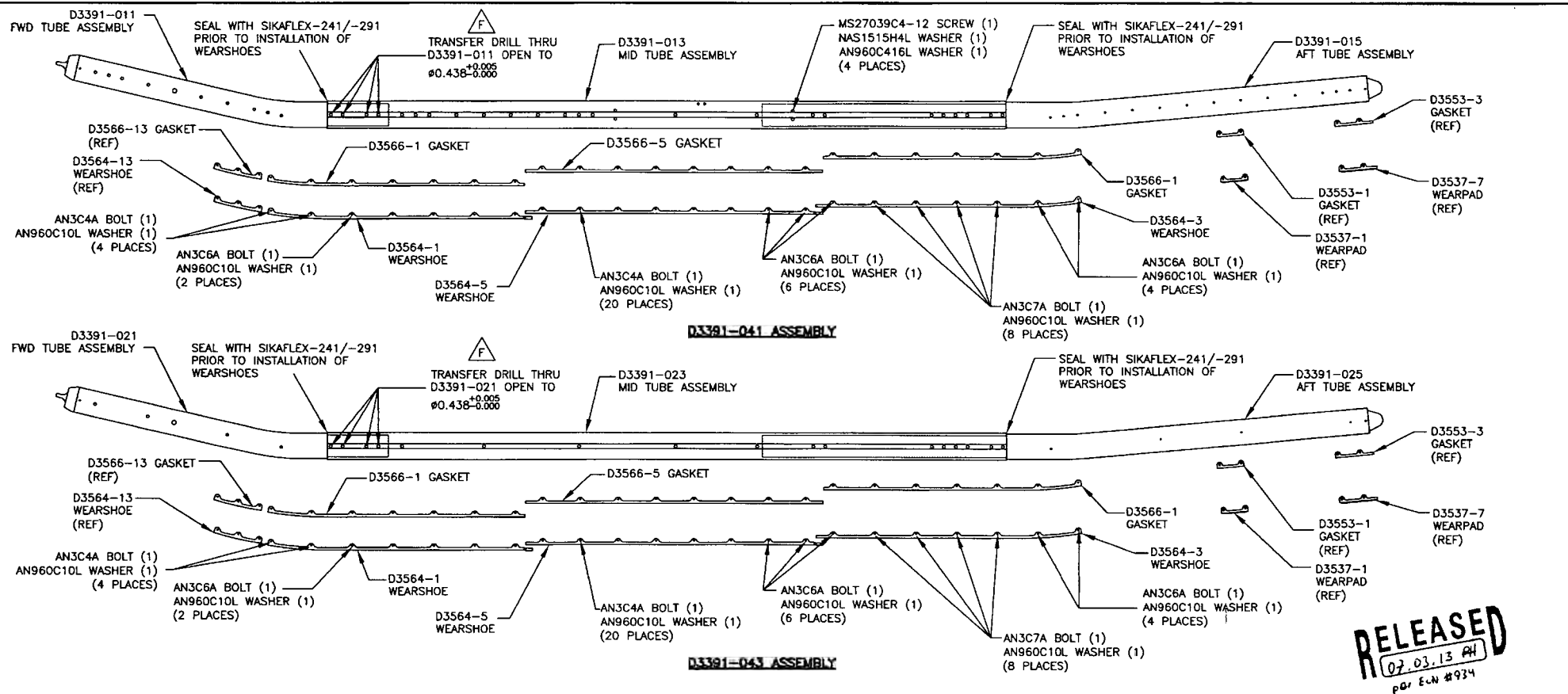
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKITUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKITUBE ASSEMBLY
		D3391-043	FLOAT SKITUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-5	WEARSHOE
1	1	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES ($\phi 0.250$ - $\phi 0.257$) FOR WEARSHOE INSERTS. C/SINK $\phi 0.391/\phi 0.425$ x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

NO. 318479
WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHOP COPY

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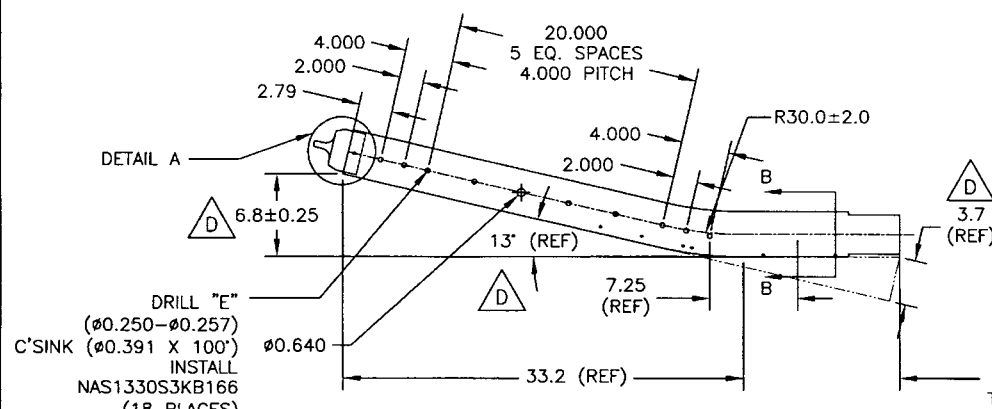
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.01.18	TITLE
		412 FLOAT SKITUBE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

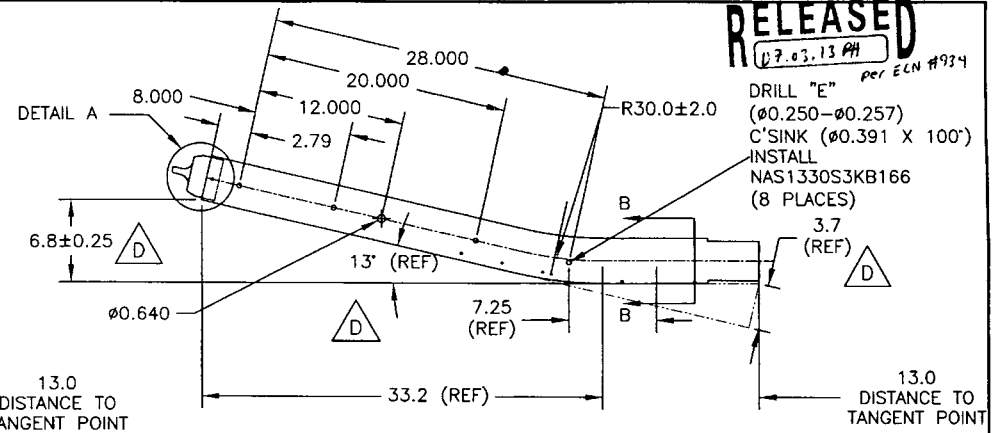
DRAWING NO. D3391
REV. F
SHEET 1 OF 5
SCALE
NTS

RELEASED
07.03.13 AH

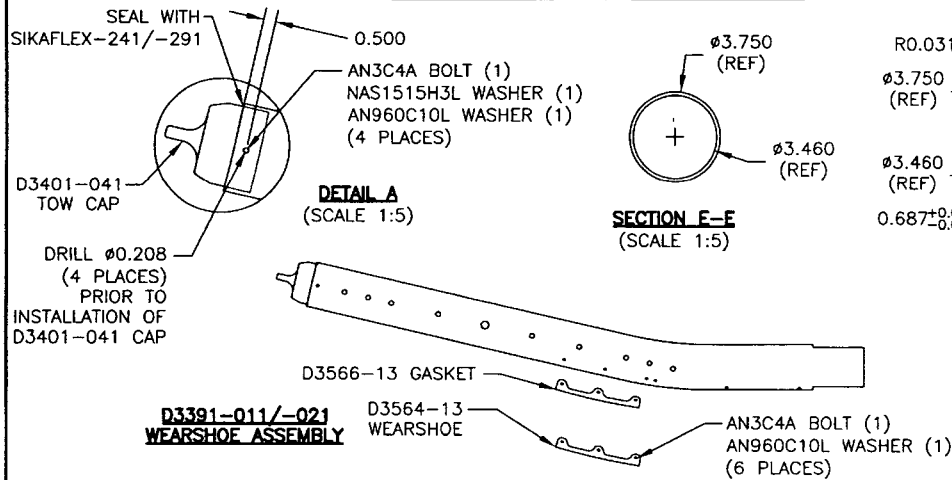
Per ELN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL



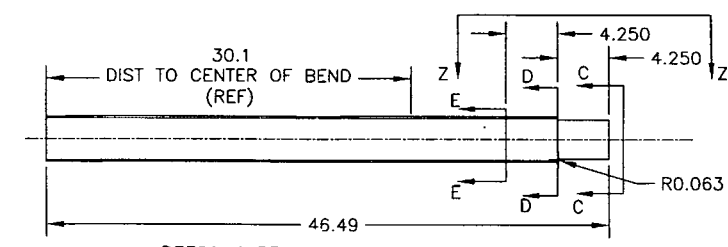
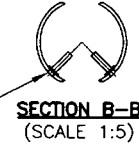
D3391-011/-021 WEARSHOE ASSEMBLY

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

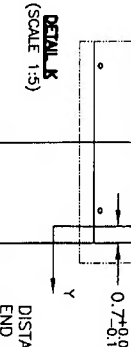
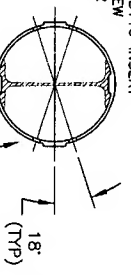
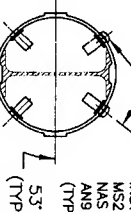
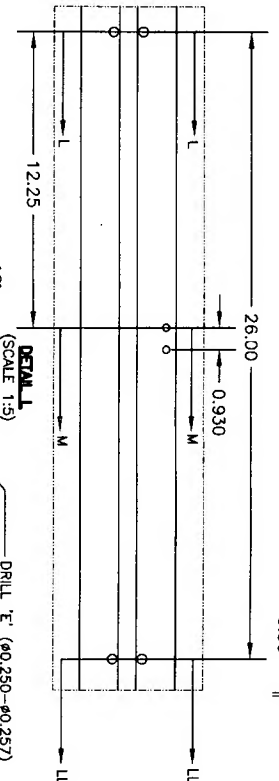
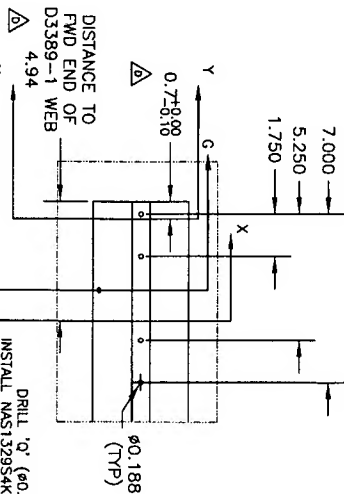
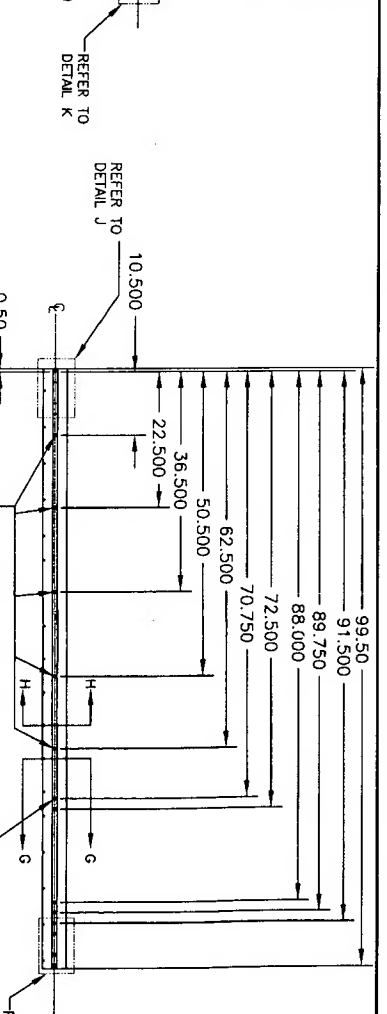
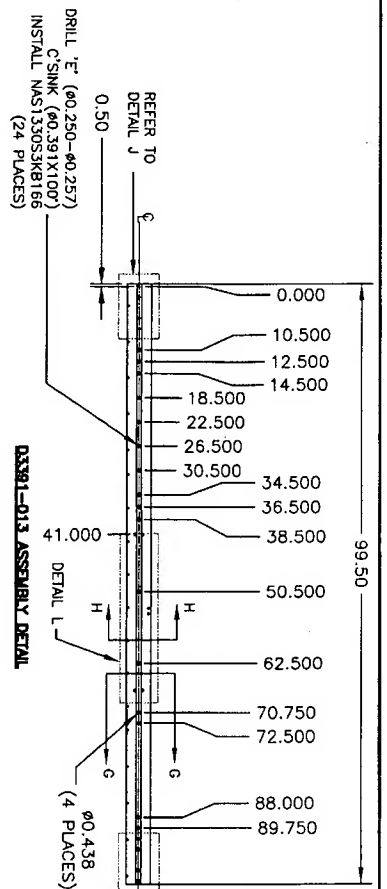
5
DRILL "E"
(Ø0.250-Ø0.257)
C'SINK (Ø0.391 X 100')
INSTALL
NAS1330S3KB166
(12 PLACES)

NO. 318249
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



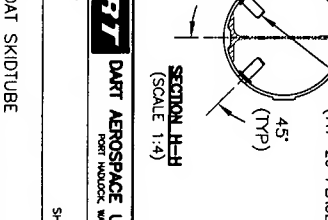
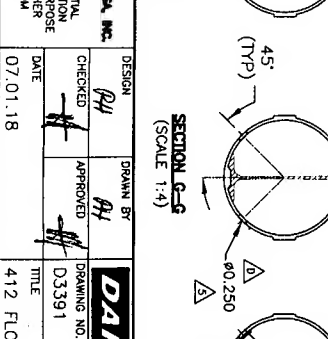
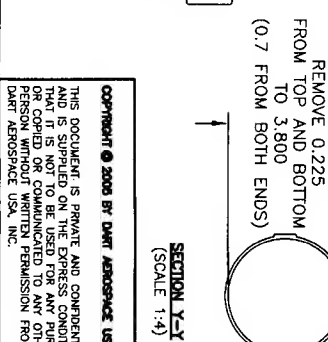
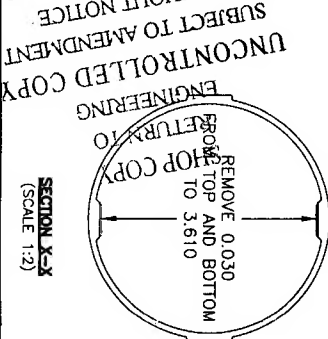
**D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)**

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391		REV. F SHEET 2 OF 5	
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10	



QTY -	QTY -	PART NUMBER	DESCRIPTION
013	023		
X	X	D3391-013	MID TUBE ASSEMBLY
X	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3XB116	INSERT (OR NAS1330C3XB116)
24	10	NAS1330S3XB166	INSERT (OR NAS1330C3XB166)
4	4	NAS1329S4XB140	INSERT (OR NAS1329C3XB140)
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER
4	4	MS27039C1-09	SCREW
4	4	MS27039C4-08	SCREW

- D3391-013/-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKATEX-241/-291 PER OSI 015



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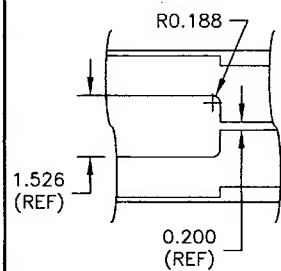
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DESIGN CHECKED *PH* DRAWN BY *PH* DART AEROSPACE USA, INC. PART NUMBER NO. **D3391**

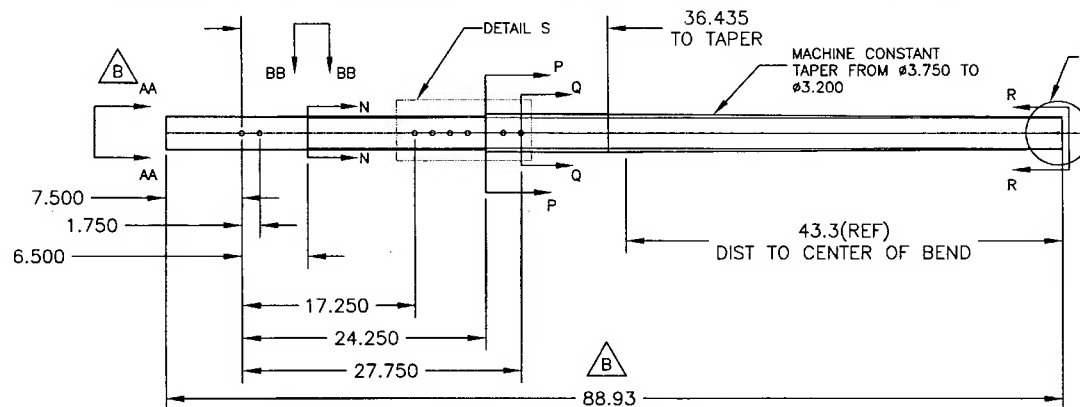
DATE 07.01.18 TITLE 412 FLOAT SKIDTUBE

REV. F SHEET 3 OF 5 SCALE 1:20

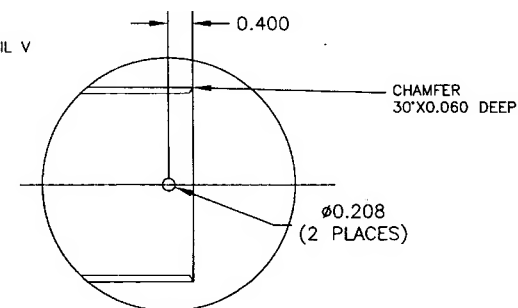
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R 03.03.13 AH
REV ECU 0934



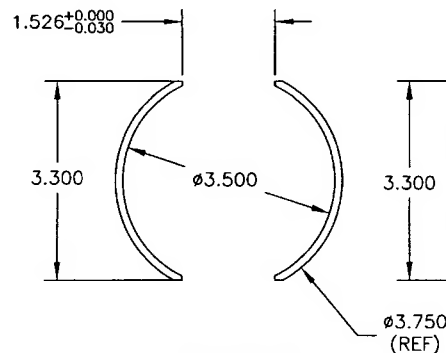
VIEW BB-BB
(SCALE 1:3)



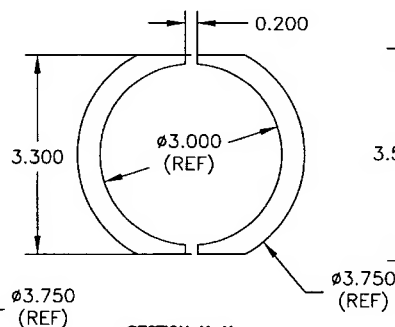
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



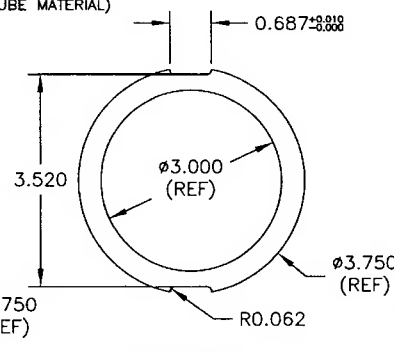
DETAIL V
(SCALE 1:2)



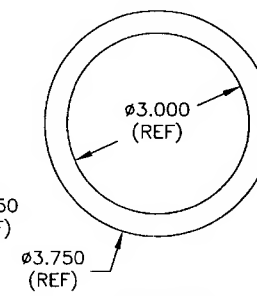
SECTION AA-AA
(SCALE 1:2)



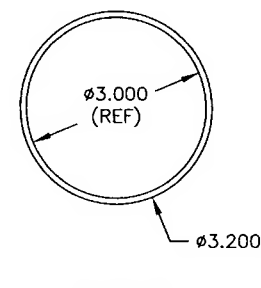
SECTION N-N
(SCALE 1:2)



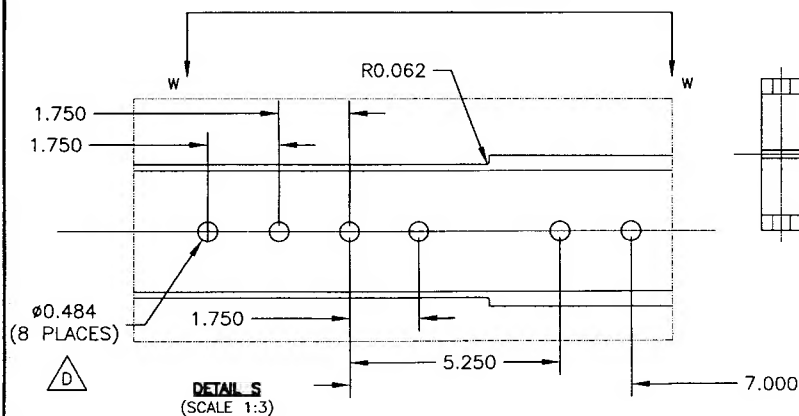
SECTION P-P
(SCALE 1:2)



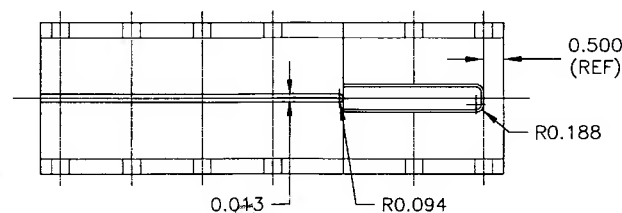
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

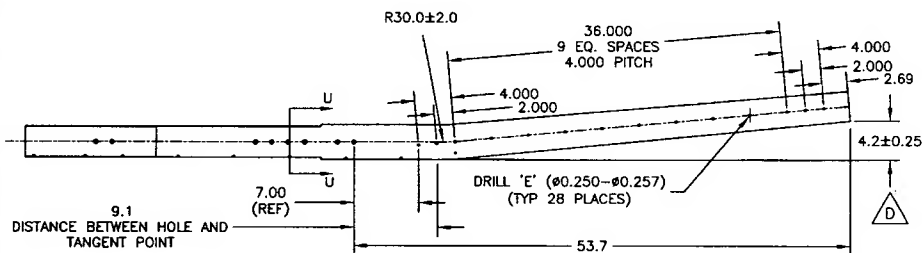
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
07.03.13 PM
PER ECN #934

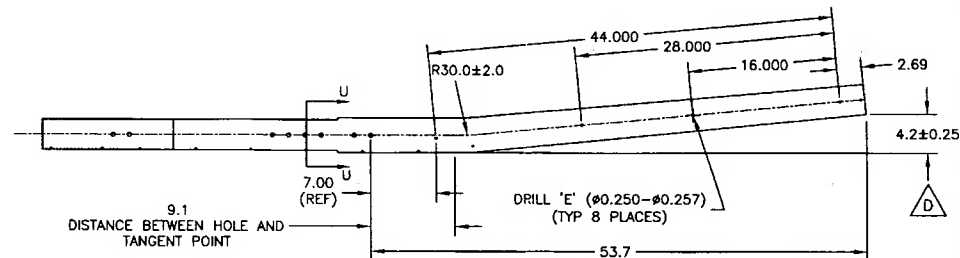
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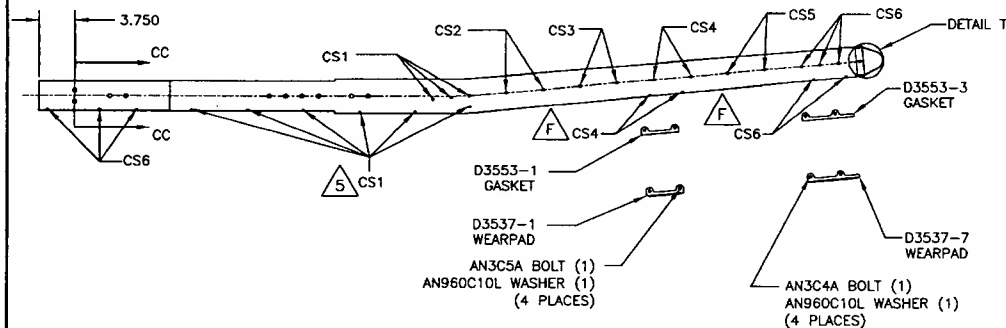
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. FORT HADLOCK, MA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



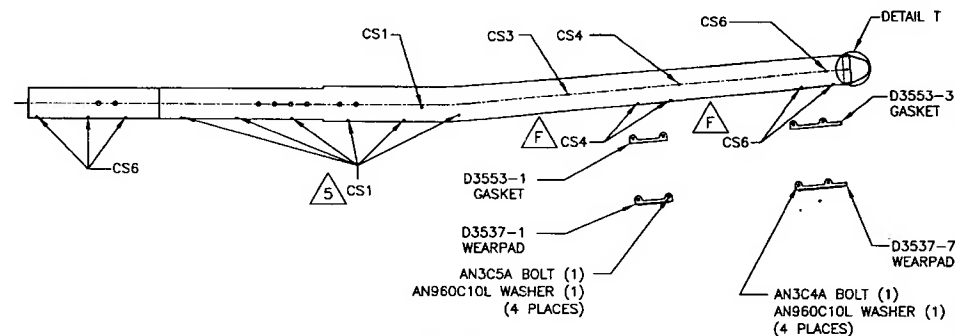
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

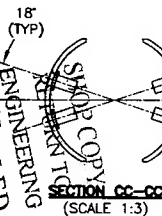


D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

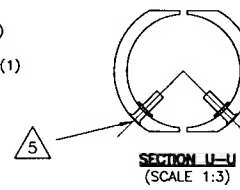
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

WORK ORDER
NO 318429
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)
DETAIL T
(SCALE 1:3)
SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DESIGN PH	DRAWN BY BL	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED
07.03.13 RH
per EGN #934

